

1. Y-carriage drilling

Increase openings in the Y-carriage to fit new u-shaped bolts for MK2S.

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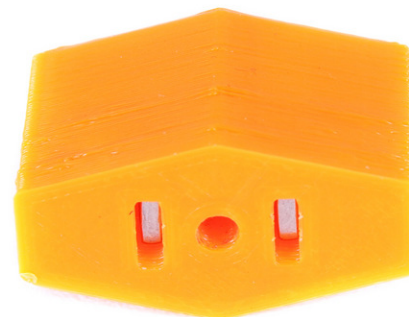
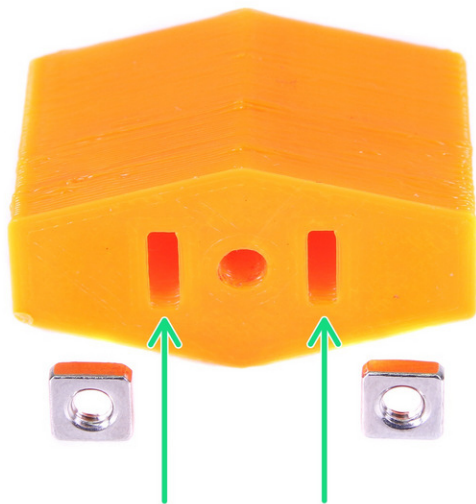
Step 1 — Assembling P-drill (Part 1)



- 3.1 mm drill bit
- P-drill
- M3x12 screws
- M3nS square nuts

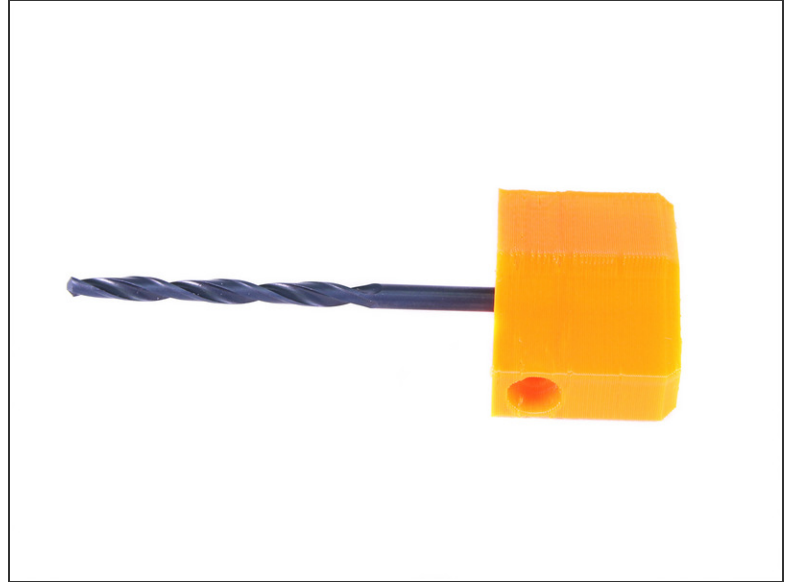
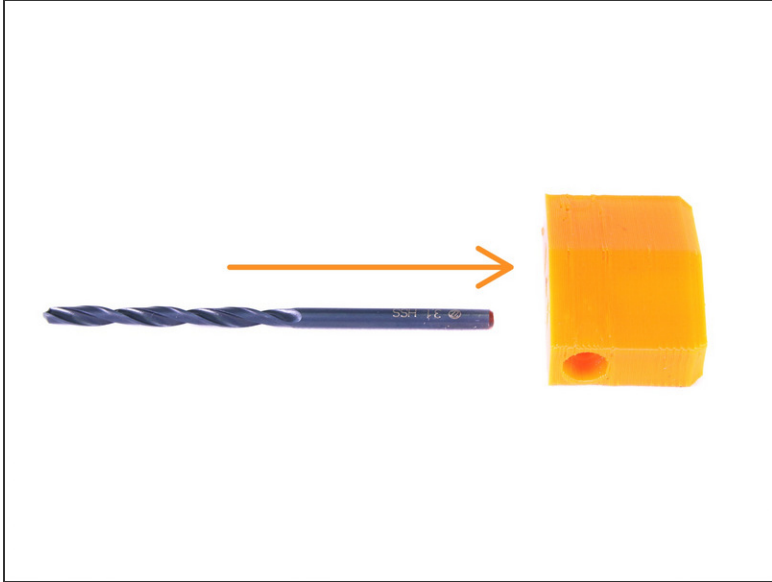
ⓘ All parts of the P-drill, including the printed part are part of the upgrade kit.

Step 2 — Assembling P-drill (Part 2)



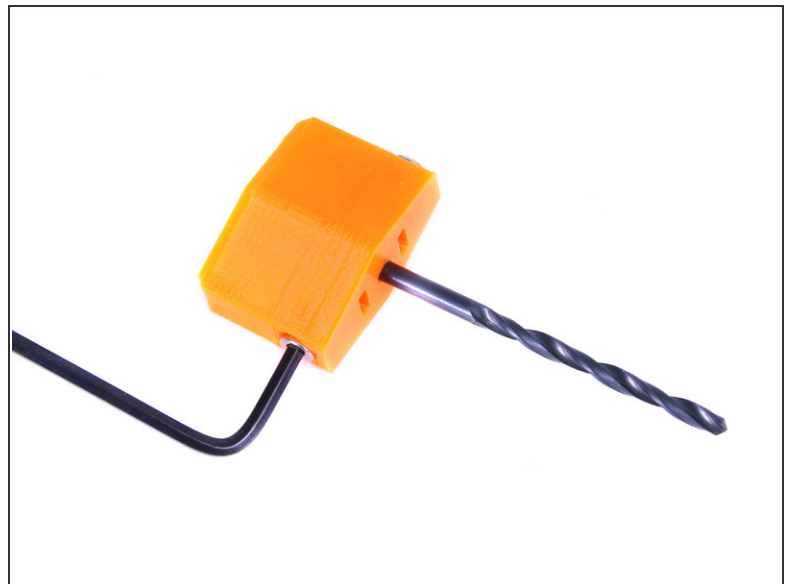
- Insert M3nS square nuts into the nut traps in the P-drill printed part.

Step 3 — Assembling P-drill (Part 3)



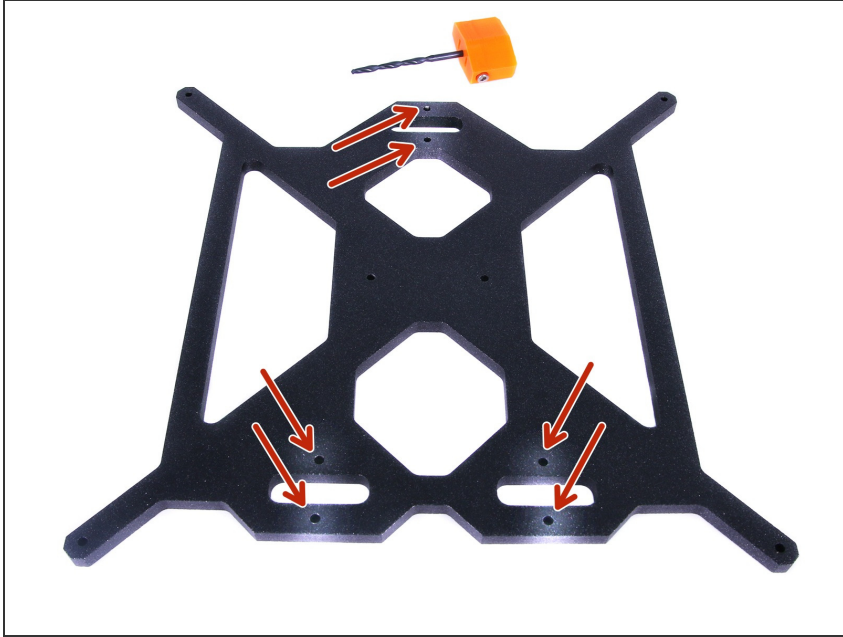
- Insert the 3.1 mm drill bit all the way into the P-drill printed part.

Step 4 — Assembling P-drill (Part 4)



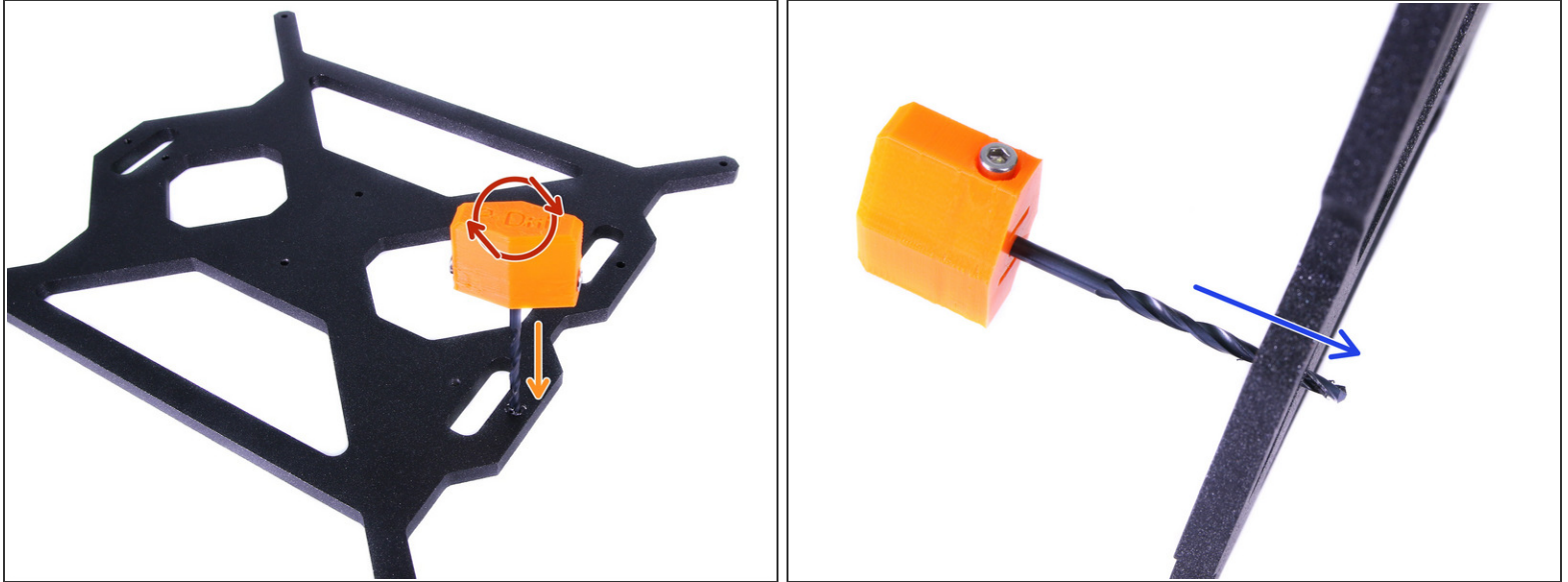
- Insert M3x12 screws into the P-drill printed part.
- Using 2.5mm Allen key tighten the screws as much as possible.

Step 5 — Drilling Y-carriage (Part 1)



- Highlighted holes are going to be drilled in next steps.

Step 6 — Drilling Y-carriage (Part 2)



- Using the assembled P-drill, drill the highlighted holes from previous step (increase the diameter of the original holes used for zip ties to secure bearings).
- Rotate with the P-drill assembly clockwise as shown in the picture.
- Apply force downward through the Y-carriage.
- ⓘ It's similar to opening a wine bottle, but don't apply that much force or the drill bit will get stuck. If it gets stuck, just rotate the opposite direction and repeat with less force.
- ☞ If the drill bit is slipping in the printed part, just tighten the M3x12 screws a little more.
- ⚠ Don't drill the Y-carriage directly on the table, you can damage the surface. Use cardboard or empty filament spool as an underlay
- Ensure the P-drill drills few millimeters through the Y-carriage.
- Proceed to the next chapter - [2. XYZ-axis reassembly](#)